

Date Thursday, 16/08/2007 11:32:37 AM
User Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 34026
 Estimate Number : 12576
 P.C. Number : N/A Part Number : D3562041
 This Issue : 16/08/2007 S.O. No. : N/A Drawing Number : D3562 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 33579 Material : N/A
 Written By : Due Date : 09/09/2007 Qty: 5 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-11-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

| Qty | Part # | Description | Batch: |
|-----|------------|-------------|--------|
| 1 | D2622-120C | Extrusion | 334014 |

Check Material for any Dents or Defects

a.m 07.10.04 (5)

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | D2734 | End Cap | 334485 |

07.10.04 5

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562 a.m 07.10.04 (5)

2-Deburr and bevel ends for welding a.m 07.10.04 (5)

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

updated on ECN 987 by RL

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/10/10 | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 34026

Part Number: D3562041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
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| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 7/10/16

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|-----|-----|---------------------------|
| 5.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

Handwritten: HX

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| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Handwritten: a.m 07.10.06

Handwritten: (5)

| | | |
|-----|-----|---|
| 7.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: FL 07/10/11

Handwritten: (5)

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|-----|----------|--------------|
| 8.0 | D3560041 | ARM WELDMENT |
|-----|----------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
ARM WELDMENT

Handwritten: B 34474

Handwritten: a.m 07.10.11 5

| | | |
|-----|----------|--------------|
| 9.0 | D3560043 | ARM WELDMENT |
|-----|----------|--------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
ARM WELDMENT

Batch: *Handwritten:* B 34474

Handwritten: a.m 07.10.11 5

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|------|--------------|-------------|
| 10.0 | MS20600AD4W5 | Blind Rivet |
|------|--------------|-------------|



Comment: Qty.: 36.0000 Each(s)/Unit Total : 180.0000 Each(s)
Blind Rivet

batch: *Handwritten:* M105 65

Handwritten: a.m 07.10.11

Handwritten: (5)

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|------|-------------|-------------------------------|
| 11.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.
Touch-up rivet holes with alodine as per dwg d3562

Handwritten: a.m 07.10.11 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Drawing Name: STEP WELDMENT

Job Number: 34026

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description:

Rivet legs using Magnabond as per dwg D3562.
Ensure to wipe off any excess magnabond of the step

~~PT 0~~

A/R Magnabond 6398

Batch: M104677

Q.M. 07.10.11 (5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



En 07/10/15 (45)
TEST PIT



Comment: INSPECT WORK TO CURRENT STEP

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M103794

07.10.16 5

2-Grind end cap welds flush as per Dwg D3562

Q.M. 07.10.16

(5)

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07.10.16 (5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/16 (45)

16.0

POWDER COATING

POWDER COATING



M105068



(5X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.B. 07/10/17

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M105694

FL 07/10/18 (5)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|-------------|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/10/11 | 11 | split up | [Signature] | 07/10/11 | 4 | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-10-24

19.0

D2808

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Spacer

mf 07-10-24

B32752 x 7mx 33mx B32886

20.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

mf 07-10-24

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07-10-24

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Assembly Kit

mf 07-10-24

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

mf 07-10-25

Job Completion



U 07-10-24

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

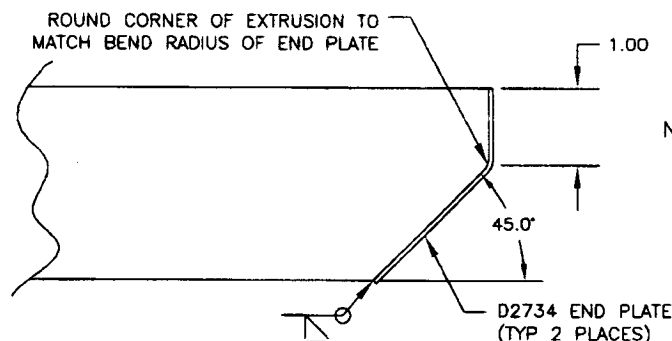
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NOTE: Date & initial all entries

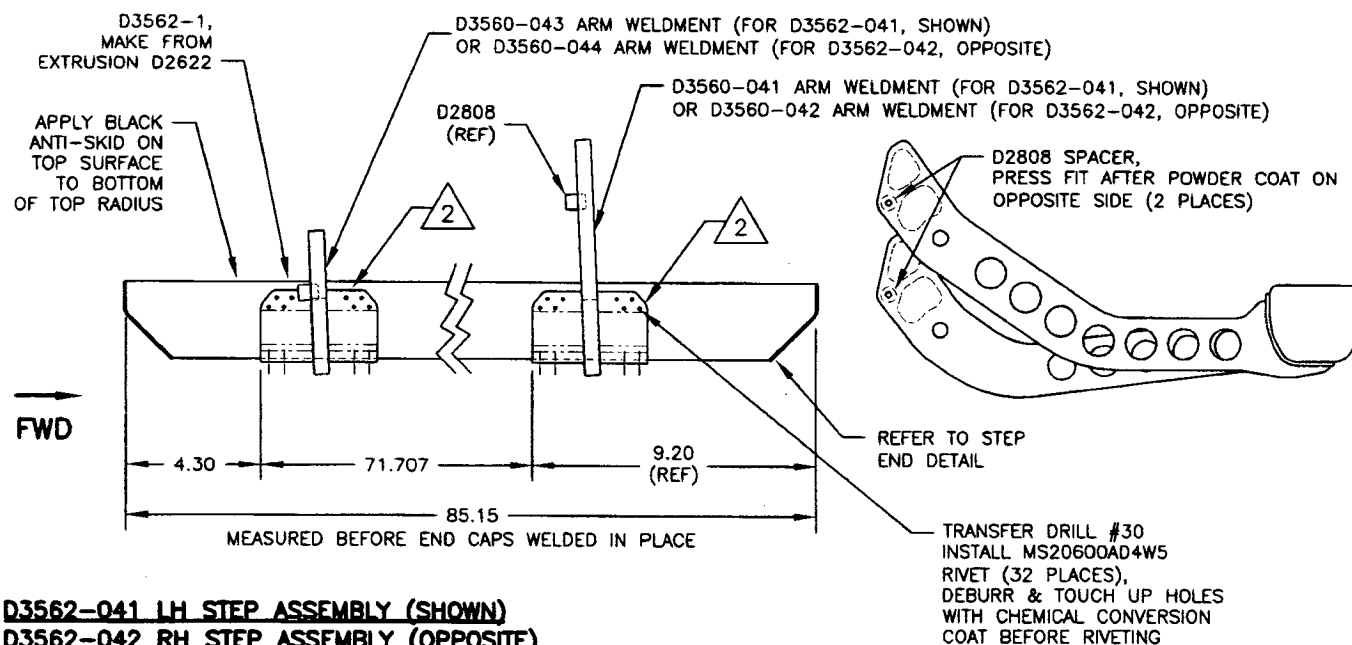


RELEASED
07.06.21-10

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

| | | | | |
|---------|----------|-----------------------------------|---------------|---|
| DESIGN | q | DRAWN BY | q | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | APPROVED | | DRAWING NO. |
| DATE | 07.06.19 | TITLE | STEP ASSEMBLY | REV. C |
| | | | | SHEET 1 OF 1 |
| | | | | SCALE |
| | | | | NTS |
| A | 06.09.26 | NEW ISSUE | | |
| B | 07.01.15 | ARMS NOW RIVETED TO STEP | | |
| C | 07.06.19 | NOW MAGBND, ADD D2808, RMV 4 RVTs | | |